

Work Order ID 136675

Wednesday, September 02, 2015 2:44:09 PM

136675

Page 1

Item ID: D6104-005 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Round Billet, 17-4
Start Date: 9/1/2015 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 9/1/2015 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: CL Date: **SEP 03 2015** Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D6104	Rev B								

100 PURCHASING 0.00 CL **SEP 03 2015** 12

100

Purchasing

Purchasing

Memo

Issue P/O: 29676 a)Description: S.S round billet b) Ø4.00" x 5.10" longc) Tolerance on all dimensions are +0.030"/-0.000" d) Material: 17-4PH Stainless steel (Ams 5643 or Aisi 630)e)One blank makes 2 partsf) Material certification required

110 Receive & Inspect for Damage & Mat'l Certs 0.00 **DAS** 12 **SEP 14 2015**

110

Packaging

Packaging

Memo

Ensure material certification is attached

120 QC18 In-Coming Inspection Material 0.00 **DAS** 12 15 **15/09/15**

120

QC

Quality Control

Memo

Ensure Material certification comply to Dwg D6104

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 136675

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Page 2

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 Start Date: 9/1/2015 Start Qty: 12.00 ***12*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>MAT043</u>	0.00							DAS 14 9-89
130						12			15/09/25
Packaging	Memo	0.00							
Packaging	LOCATION: MAT043								
140	QC21- Final Inspection - Work Order Release	0.00							
140									MCS SEP 15 2015
QC	Memo	0.00							
Quality Control									

20150915
 SA

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval				
Description Work Order Deviation				Disposition				Completed By			
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : ☐											

Picklist Print

Wednesday, September 02, 2015 2:44:09 PM

Page 1

Work Order ID: 136675

136675

Parent Item: D6104-005

D6104-005

Parent Item Name: Round Billet, 17-4

Start Date: 9/1/2015

Required Date: 9/1/2015

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP A: 01.05.08New Issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6104-005P		Purchased		No		110	Each	0.0000	1	12			

D6104-005P

17-4 SS Roundbar 4.00"Od

DAS
6
9-89

SEP 1 5 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

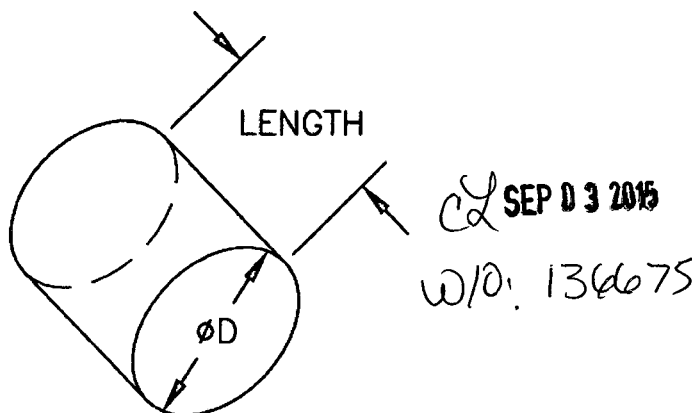
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							



DESIGN <i>RF</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6104	Rev. B SHEET 1 OF 1
DATE 02.11.25		TITLE ROUND BILLET, 17-4	SCALE NTS
A	01.04.10	NEW ISSUE	
B	02.11.25	CLARIFY ALLOY SPEC ADDED D6104-009/-011 REDUCE LENGTH OF BILLETS	

RELEASED
02.11.29 *[Signature]*

SPECIFICATION CONTROL DRAWING



MATERIAL: 17-4 PH SS (AMS 5643 OR AISI 630) MIN UTS = 170 KSI (38 HRc)

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, DIAMETER x LENGTH (+0.030/-0.000) AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES

Part No.	Alloy	D (Diameter)	Length
D6104-001	17-4 PH STAINLESS STEEL	Ø3.00	3.80
D6104-003	17-4 PH STAINLESS STEEL	Ø3.25	3.80
D6104-005	17-4 PH STAINLESS STEEL	Ø4.00	5.10
D6104-007	17-4 PH STAINLESS STEEL	Ø4.50	5.10
D6104-009	17-4 PH STAINLESS STEEL	Ø5.25	4.10
D6104-011	17-4 PH STAINLESS STEEL	Ø6.50	4.10

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO29676

Purchase Order Date 9/3/2015

PO Print Date 9/3/2015

Page Number 1 of 2

Order From :
METAUX CASTLE
P.O. BOX 4090 STN A
TORONTO, ONTARIO M5W OE9
CANADA

VU-MET002

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FOAMED

Contact Name

Vendor Phone

Ship To Contact

Ship To Phone

Ship Via: Yours ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D6104-005P AS PER DWG D6104 REV. B B136675 MATERIAL: 17-4 PH AS PER AMS 4643 OR AISI 630 SIZE: 4.00" X 5.10" LONG	17-4 SS Roundbar 4.00"Od	9/21/2015 Yes 9/21/2015		12.00 Each	\$59.17	\$710.08
Line Total:							\$710.08
2	71401-45 Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A026 certification of materila conformance A041 quality management system A042 dart notification by supplier A043 retention of quality documents	PROCUREMENT QUALITY CLAUSES	9/21/2015 No 9/21/2015		1.00	\$0.00	\$0.00

Note:

9/3/2015



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO29676**

Purchase Order Date 9/3/2015

PO Print Date 9/3/2015

Page Number 2 of 2

Order From :

VU-MET002

METAUX CASTLE
P.O. BOX 4090 STN A
TORONTO, ONTARIO M5W OE9
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

Ship To Contact

Ship To Phone

Ship Via: Yours ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency USD

FOB Destination-Collect

Line Total: \$0.00

PO Total: \$710.08

CL *W*
Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 9/3/2015

**Castle Metals®**

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 1 of 1

Shipment No:2721499

Ship From: A. M. Castle & Co. (Canada) Inc. MONTREAL - CASTLE METALS 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped	F.O.B.	Freight Terms		Carrier		BOL No	
10-SEP-2015	ORIGIN	Prepaid		MANITOULIN		2721499-2	

Shipment Details	Final Destination Branch - MON
-------------------------	---------------------------------------

Order No	Line No	Item No	Description				
4047925	1	42464.MO	4.0000.RD.17CR-4NI.STAINLESS.RT.SOL TR.COND A.132.0000-156.0000 CUT TO 5.1 IN (+ .1250/- .0000 IN) - BAND SAW CUTTING SPECIFICATIONS: AMS 5643				
Purchase Order No		Part Number		Ordered Qty		Invoice Qty	
29676		YOUR ITEM NUMBER: D6104-005		12.00 PCS 15/9/14		12.00 PCS	
Details		END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS					
Delivery No.	Mill	Heat Number	Mech Id	PCS	Width (IN)	Length (IN)	Shipped Qty(LBS)
120173732	NORTH AMERICAN STAINLESS			12			224.7488

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

Reviewed by Authorized Castle Metals Representative:

Date: 10 SEP. 2015
Name:These commodities, technology or software were exported from the United States in accordance with the Export Administration Regulations. Diversion contrary to US law prohibited.
Date Printed: 10-SEP-2015 08:17:29 AM



**NORTH AMERICAN
STAINLESS**

METALLURGICAL TEST REPORT

6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000

Certificate: 946402 05
Customer: 0032 001
NAS Order: LP 15233 1
Your Order: 266595

Mail To:
A.M. CASTLE AND COMPANY
1420 KENSINGTON ROAD-SUITE 220
OAK BROOK IL 60523

Ship To:
A.M. CASTLE AND COMPANY
3400 NORTH WOLF ROAD
FRANKLIN PARK IL 60131

Date: 5/06/2014 Page: 1 of 1
Steel: 630 (17-4)
Finish: Hot Finish
Dia/Thk: 4.0000 in
Leg Length:
Length: 144.00 in
Corrosion:

Item Code: 42464

PRODUCT DESCRIPTION:

AMS 2303E, AMS 5643R
Round Bar, Hot Rolled, Annealed, Rough Turned
UNS S17400; EN 10204 3.1, ASTM A484/11, MACRO OK, AMS 5643T
ASTM A564/10, AMS 2303, ASME SA564-07, ASTM F899/11 (CHEM ONLY)
SOL. ANNEALED @ 1900F MIN FOR 1 HR MIN. and air cooled to RT

REMARKS:

COMPLIES W/REQUIREMENTS OF D FAR 252.225-7009 EU DIRECTIVE
2011/65/EU. RoHS. EAF+AOD+CC. NO WELD REPAIR. MELTED AND MFG
IN USA FREE FROM MERCURY AND LOW MELTING ALLOY CONTAMINATION

DAS
14
9-89

15/09/15

Bundle Weight	Bundle Weight	Bundle Weight	Bundle Weight	Bundle Weight	Bundle Weight	Bundle Weight	Bundle Weight	Bundle Weight	Bundle Weight
BG30082	2067								

CHEMICAL ANALYSIS CM(Country of Melt) ES(Spain) US(United States) ZA(South Africa) JP(Japan)

Chemical Analysis per ASTM A751/08

Heat	Supplier #	CM	C %	CB %	CO %	CR %	CU %	MN %	MO %	N %	NI %	P %
M178		US	.023	.218	.08	15.21	3.17	.80	.04	.045	4.19	.033
			S %	SI %	TA %	TI %						
			.0245	.47	.0175	.0020						

MECHANICAL PROPERTIES

	1 d o i c f	HB No.	Grain No.	Ferrite %	TS-900CAP KSI	YS-900CAP KSI	E1-900CAP % 4D	RA-900CAP %	RC-900CAP No.	FREQ. No.	SEV. No.
BG30082	R L	341.0	8.0	.10	202.98	178.79	13.65	45.97	42.0	.16	.09

NAS hereby certifies that the analysis on this certification is correct. Based upon the results and the accuracy of the test methods used, the material meets the specifications stated. These results relate only to the items tested and this report cannot be reproduced, except in its entirety, without the written approval of NAS

Technical
Dept. Mgr.

ERIC HESS

Castle Metals FP

HEAT NUMBER MIF8
MECHANICAL ID _____
ITEM CODE 42464
LOT NUMBER _____
PO NUMBER 266595
RECEIPT DATE 5-8-14
SUPPLIER N/A
SPECIFICATION _____
LCS _____
COMMENT _____
APPROVED (Signature)

BON DE CONNAISSANCE NOMINATIF ABRÉGÉ - ORIGINAL - NON NÉGOCIABLE STRAIGHT BILL OF LADING - SHORT FORM - ORIGINAL - NOT NEGOTIABLE REÇU, Sujet aux classifications et tarifs en vigueur à la date d'émission du présent bon de connaissance RECEIVED, Subject to the classification and tariffs in effect on the date of issue of this Bill of Lading. Le bien décrit plus bas, en bon état apparent, exception faite comme noté (le contenu et la condition du contenu de l'emballage inconnus), marqué, consigné et destiné comme indiqué ci-après, que le dit transporteur (le mot « transporteur » signifiant dans ce contrat toute personne ou société en possession du bien en vertu de ce contrat) accepte de le transporter à l'endroit habituel de livraison de ladite destination, si sur sa route, ou sinon de le livrer à un autre transporteur en route vers ladite destination. Il est mutuellement accepté, par chacun des transporteurs de toute ou n'importe quel dit bien, en totalité ou en partie de la route à destination, et par chaque partie intéressée par la totalité ou n'importe quelle partie du bien à n'importe quel moment, que chaque service à être exécuté tel que décrit ci-après est sujet à toutes les modalités et conditions générales du bon de connaissance nominatif « Uniform Domestic Straight Bill of Lading » présenté (1) dans la Classification uniforme de transport en vigueur à la date des présentes, s'il s'agit d'une expédition par voie ferroviaire ou par voie marine, ou (2) dans la classification ou le tarif applicable au transporteur motorisé s'il s'agit d'une expédition par véhicule motorisé. The property described below, in apparent good order, except as noted (contents and condition of contents of packages unknown), marked, consigned, and destined as indicated below, which said carrier (the word carrier being understood throughout this contract as meaning any person or corporation in possession of the property under the contract) agrees to carry to its usual place of delivery at said destination, if on its route, otherwise to deliver to another carrier on the route to said destination. It is mutually agreed, as to each carrier of all or any said property over all or any portion of said route to destination, and as to each party at any time interested in all or any of said property, that every service to be performed hereunder shall be subject to all the terms and conditions of the Uniform Domestic Straight Bill of Lading set forth (1) in Uniform Freight Classification in effect on the date hereof, if this is a rail of rail-water shipment, or (2) in the applicable motor carrier classification or tariff this is a motor carrier shipment.		No du livreur / Shipper No.: 2721499-2 De - A / FROM AT: A. M. Castle & Co. (Canada) Inc. 835-SELKIRK AVENUE POINTE CLAIRE QC H9R 3S2 CAN d expédition / Ship Date: 10-SEP-2015
Consigné à / Consigned To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY ON K6A 1K7 CAN		Directives de livraison / Delivery instructions: TOUS LES CHARGEMENT DOIVENT ÊTRE COUVERT. LA LISTE D'EMBALAGE DE LIVRAISON ET LES RAPPORTS DE TEST OU CONSIGNATAIRES REFUSERONT. ALL LOADS MUST BE TARPED. DELIVER PACKING LIST AND TEST REPORTS OR CONSIGNEE WILL REFUSE.
Nom du Transporteur / Carrier Name: MANITOULIN		Modalités de paiement / Payment Terms: Prepaid REMETTRE LES FACTURES DE TRANSPORT À / REMIT FREIGHT INVOICES TO: RayTrans Management, Inc. PO Box 1210 Washington PA 15301
Couverture d'assurance additionnelle / Additional Insurance Coverage: La valeur accepté ou déclaré de la propriété ci bas spécifiée par le transporteur n'excède pas : The agreed or declare value for the property is hereby specifically stated by the shipper to be not exceeding: _____ par / per _____		

MANITOULIN TRANSPORT 1-800-265-1485



Détail de livraison / Shipment Breakdown:

Quantité / Quantity	Emballage / Packaging	Classe / Class	Commodity
1	BOX	FAK 50	Metal Product

Poids du Chargement / Shipment Weights:

Produit / Product	225 LBS
Dunnage	35 LBS
Gross	260 LBS

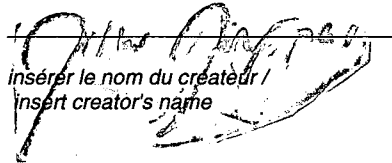
ORDER DETAIL:

Bon de commande du client / Customer PO	No de commande du client / Sales Order No.	No de ligne / Line No.	No. d'Item Castle / Castle Item No.	Quantité livrée / Quantity Shipped	Castle UOM
29676	4047925	1	4047925*1*1*318385627	12	PCS

Sujet à la section 7 des Conditions générales du Bon de connaissance applicable. Si cette expédition est livrée au consignataire sans recourir à l'expéditeur, l'expéditeur doit signer les déclarations suivantes. Subject to Section 7 of Conditions of applicable bill of Lading. If this shipment is to be delivered to the consignee without recourse to the consignor, the consignor shall sign the following statements. Le transporteur ne doit pas livrer ce chargement sans avoir acquitté les frais de transport et les charges légales. The carrier shall not make delivery of this shipment without payment of freight and all other lawful charges.	Si l'expédition se déplace entre deux ports par un transporteur par voie maritime, la loi exige que le bon de connaissance stipule s'il s'agit « du poids du transporteur ou de l'expéditeur ». NOTE : Là où la charge est en fonction de la valeur, les expéditeurs doivent déclarer spécifiquement par écrit la valeur du bien acceptée ou déclarée. If the shipment moves between two ports by a carrier by water, the law requires that the bill of lading shall state whether it is "carrier's or shipper's weight." NOTE: Where the rate is dependent on value, the shippers are required to state specifically in writing the agreed or declared value of the property.
CETTE EXPÉDITION DOIT ÊTRE REÇUE ET TRANSPORTÉE CONFORMÉMENT À TOUTES LES MODALITÉS ET CONDITIONS GÉNÉRALES DU BON DE CONNAISSANCE COMPAGNIES DE NAVIGATION. THIS SHIPMENT IS TO BE TENDER RECEIVED AND TO BE CARRIED SUBJECT TO ALL TERMS AND CONDITIONS OF THE STEAMSHIP COMPANIES CURRENT FORM BILL OF LADING.	L'expéditeur déclare spécifiquement que la valeur acceptée ou déclarée du bien ne dépasse pas. The agreed or declared value of the property is hereby specifically stated by the shipper to be not exceeding
CE DOCUMENT CERTIFIE QUE LES ARTICLES MENTIONNÉS CI-DESSUS SONT PROPREMENT CLASSIFIÉS, DÉCRITS, EMBALLÉS, MARQUÉS ET IDENTIFIÉS, ET SONT EN ÉTAT D'ÊTRE TRANSPORTÉS CONFORMÉMENT AUX RÈGLEMENTS DU MINISTÈRE DES TRANSPORTS. THIS IS TO CERTIFY THAT THE ABOVE NAMED ARTICLES ARE PROPERLY CLASSIFIED, DESCRIBED, PACKAGED, MARKED AND LABELED, AND ARE IN PROPER CONDITION FOR TRANSPORTATION ACCORDING TO THE APPLICABLE REGULATIONS OF THE DEPARTMENT OF TRANSPORTATION.	Le client est responsable de tous les documents d'expédition et de se conformer à toutes les lois canadiennes et américaines incluant, mais sans s'y limiter, les lois et règlements américains et canadiens relatifs à l'exportation. Customer is responsible for all shipping documents and compliance with United States and Canadian laws, including but not limited to U.S. and Canadian Export laws and regulations.



EXPÉDITEUR - PAR /
SHIPPER, PER:


insérer le nom du créateur /
insert creator's name

Par /
Per

Signature du conducteur /

Date

Driver's Signature

PREUVE DE LIVRAISON /
PROOF OF DELIVERY:

Signature / Date

Name

Please Print Name Here

Toutes les pages doivent être signées/ All pages must be signed

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6104-005
 DATE: 15/09/15

PO / BATCH NO: 29676/136675

MATERIAL CERT REC'D: yes
 QUANTITY RECEIVED: 12
 QUANTITY INSPECTED: 12
 QUANTITY REJECTED: _____

THICKNESS ORDERED: 84.00X5.10
 THICKNESS RECEIVED: 84.040X5.220
 SHEET SIZE ORDERED: _____
 SHEET SIZE RECEIVED: _____

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	☒ N	
CORRECT FINISH	☒ Y	N	
CORROSION	Y	☒ N	
CORRECT GRAIN DIRECTION	☒ Y	N	
CORRECT MATERIAL	☒ Y	N	
CORRECT THICKNESS	☒ Y	N	
PHOTO REQUIRED	Y	☒ N	
CORRECT MATERIAL	☒ Y	N	
CORRECT REF # TO LINK CERT	☒ Y	N	
CORRECT MATERIAL IDENTIFICATION	☒ Y	N	
CORRECT M# ON THE MATERIAL	☒ Y	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
TYPE OF MATERIAL	HRC	HRB	DUR A	DUR D	
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>14</u> <u>9-89</u>	SIGNED OFF BY: _____		
DATE: <u>15/09/15</u>	DATE: _____		

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

MATERIAL RECEIPT INSPECTION FORM

INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

- 1- VERIFY STOCK TO DART PURCHASE ORDER
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
 - a. WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORRECT TO THE DART PO INSTRUCTIONS
- 6- REMOVE / CUT A PIECE OF MATERIAL FOR SAMPLE HARDNESS TESTING

INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

- 1- VERIFY TO DART SUPPLIED DRAWING
- 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVED INTO DART
- 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
- 4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

AFTER MATERIAL PASSES INSPECTION

- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN 20pcs FOR FULL INSPECTION
- 6- INSPECT ALL DIMS AS PER DRAWING REQUIREMENTS

INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIREMENTS ON THE DART DRAWINGS
- 2- INSPECT MIN. HALF THE BATCH OF EXTRUSION RECEIVED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
 - a. WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
 - b. OUTSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - c. INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - d. STRAIGHTNESS @ CENTER OVER 12" SPAN
 - e. WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTIFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2.....) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC COORDINATOR BEFORE GOING FURTHER